

Date: Wednesday, 2/20/2008 4:24:07 PM
User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	SADDLE, OUTBOARD, LH, 206		
Job Number	37549		Part Number	D26651		
Estimate Number	10818		Drawing Number	D2665 REV.D		
P.O. Number			Project Number	N/A		
This Issue	2/20/2008	S.O. No.	Type	MACHINED PARTS	Drawing Revision	D
Prsht Rev.	NC		Material			
First Issue	/ /		Due Date	3/10/2008	Qty:	4
Previous Run	37330		Um:	Each		
Written By	<u>JLJ 08/02/01</u>					
Checked & Approved By						
Comment	Est: C 00.11.01 Removed P/O for Powder Coat - in house processEC Est Rev:D As per Rev D 07-03-19 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101003	7075-T7351 2X6.25X7.875	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) 7075-T7351 2X6.25X7.875 Cut Size 2.0" x 6.25" x 7.88" Grain Along Long 7.88 Length Batch no. <u>3 34873</u> <u>DTP 08/05/01</u>	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program batch number. 1- Inspect part number and batch number are programmed correctly. 2- Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet 3- Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet 4- Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet 5- Deburr <u>DTP 08/05/01</u>	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet <u>DTP 08/05/01</u>	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>DTP 08/05/01</u>	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SADDLE, OUTBOARD, LH, 206

Job Number: 37549

Part Number: D26651

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

MF 08-05-06 (4)

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

1337549

026651

05/05/2008

S.189 5.16

#1 324.5 F

#2 - - - F

#3 30 min F

#4 - - - F

7.0 POWDER COATING POWDER COATING



M107550

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

MF 08/05/05

(4)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 436

AS 08/05/06

(4)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



08/05/06 (4)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-06

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD			Work Order:	37549
Description: 206 Saddle, Outboard, Left side			Part Number:	D2665-1
Inspection Dwg: D2665 Rev. D			Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. D and record below:

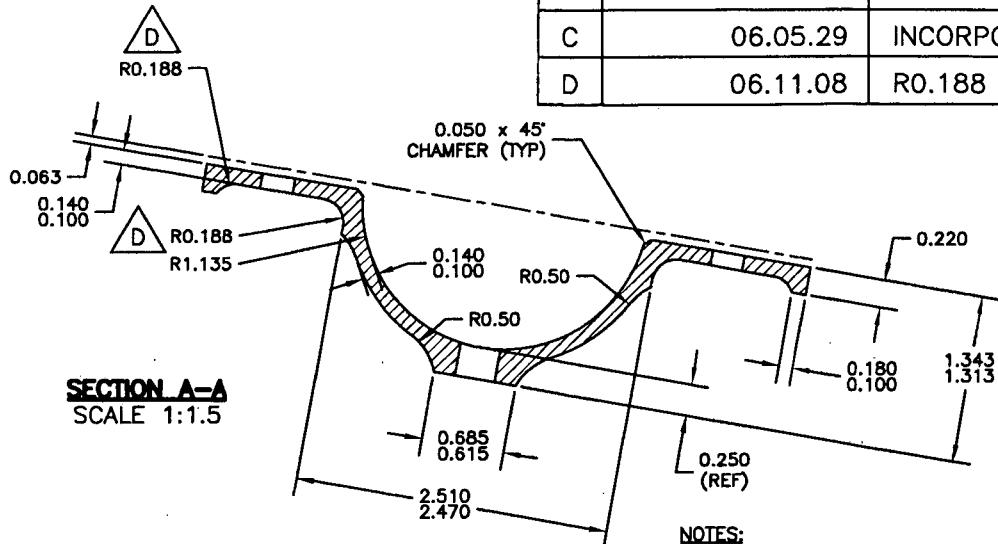
Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.124	0.124	0.125	0.125		
B	0.100	0.140		0.123	0.125	0.125	0.124		
C	1.125	1.145		1.131	1.1395	1.1321	1.1341		
D	0.615	0.685		0.645	0.645	0.645	0.645		
E	0.240	0.260		0.255	0.255	0.255	0.255		
F	1.313	1.343		1.3245	1.3245	1.3245	1.3245		
G	0.210	0.230		0.222	0.222	0.222	0.223		
H	0.100	0.180		0.160	0.160	0.160	0.160		
I	2.470	2.510		2.495	2.495	2.495	2.495		
J	1.565	1.585		1.572	1.572	1.572	1.572		
K	0.235	0.240					0.237		
L	0.100	0.120		0.110	0.110	0.110	0.110		
M	0.990	1.010		1.000	1.000	1.000	1.000		
N	0.510	0.515					0.510		
O	5.990	6.010		6.002	6.002	6.002	6.002		
P	1.245	1.255		1.250	1.247	1.249	1.249		
Q	2.495	2.505		2.499	2.498	2.500	2.500		
R	0.313	0.318		0.314	0.314	0.314	0.314		
S	0.315	0.322		0.322	0.322	0.322	0.322		
T	2.495	2.505		2.500	2.500	2.499	2.499		
U	1.357	1.367		1.362	1.362	1.360	1.361		
V	0.787	0.807		0.7945	0.795	0.795	0.795		
W	0.540	0.560		0.555	0.555	0.555	0.555		
X	1.674	1.684		1.679	1.679	1.679	1.677		
Y	0.257	0.262		0.259	0.259	0.255	0.259		
Z	0.912	0.932		0.923	0.923	0.923	0.923		
AA	0.490	0.510		0.502	0.502				
AB	0.178	0.198	0.188	0.188	0.188	0.188	0.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	<i>DT</i>	Audited by:	<i>SC</i>
Date:	08/05/01	Date:	08-05-01

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	<i>JLM</i>
F	07.03.21	Revised per drawing revision D	KJ/JLM	<i>JLM</i>

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2665 REV. D SHEET 1 OF 1
DATE		TITLE SADDLE FWD OUTSIDE HIGH SCALE 1:3
06.11.08		
A	97.03.25	NEW ISSUE
B	97.07.11	ANGLE AND NOTES ADDED
C	06.05.29	INCORPORATE DEO 9122, 9102, 9095
D	06.11.08	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313

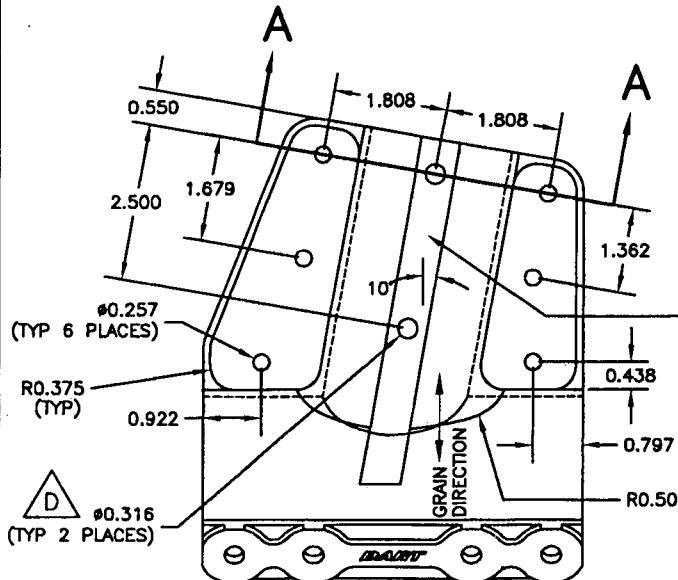


RELEASED

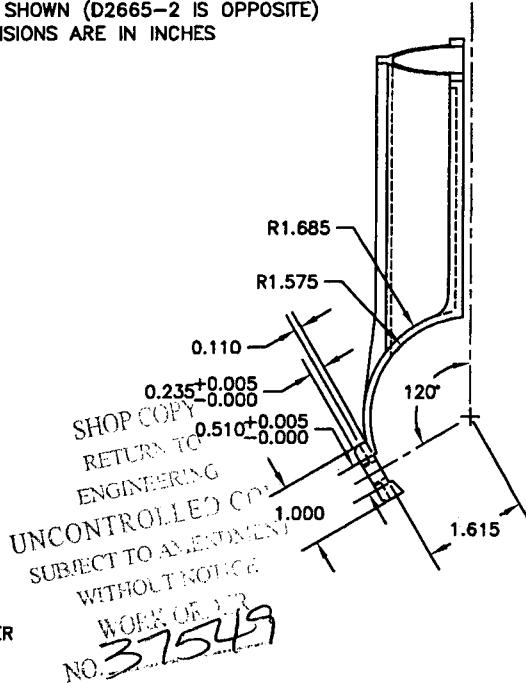
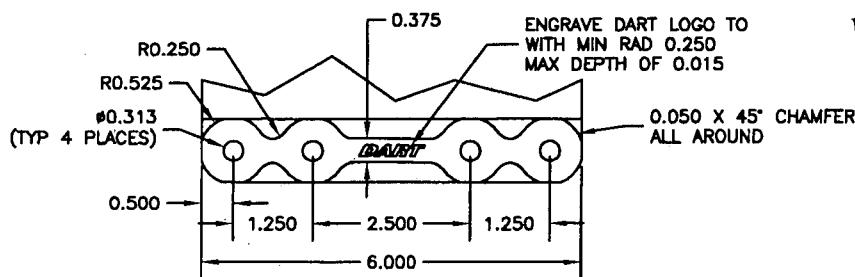
07.02.12 AF

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2665-1 SHOWN (D2665-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



ENGRAVE PART NUMBER AND BATCH NUMBER TO MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010



D2665-1 SADDLE FWD OUTSIDE HIGH

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